

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003445**Date Inspected:** 14-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Yi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

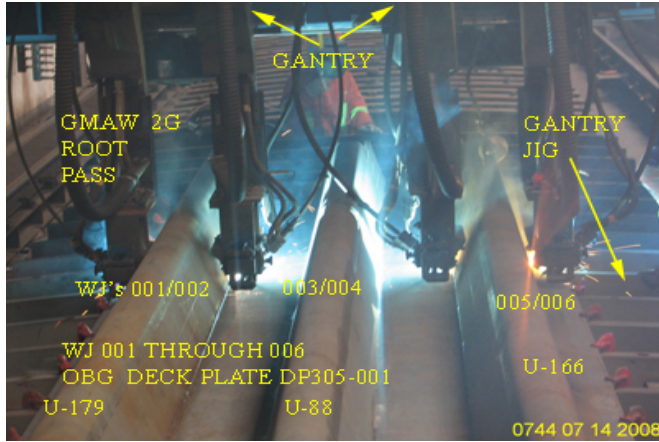
OBG Bay 1:

The QA Inspector randomly observed ZPMC welders Zhong Li Ping ID Number 201840, Zhao Cheng Sheng ID Number 059400, Xu Guo Yin ID Number 059443 and Juang Shuang Chen ID Number 281788, utilizing gantry mounted welding apparatus with the Gas Metal Arc Welding (GMAW) Process in the 2G (Horizontal Groove) Position with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2342-U1(U-Rib)-3, to weld the root pass for U-Ribs to Deck Plate Sub-Assembly DP305-001 at Weld Joint (WJ) Numbers DP305-001-001/002(U-179) and 005/006(U-166). The QA Inspector randomly observed ZPMC CWI Chen Yi monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 368/371 amps, 30.5/30.4 volts (WJ 001/002) for Mr. Zhong/Mr. Zhao and 372/375 amps, 30.2/30.7 volts (WJ's 005/006) for Mr. Xu/Mr. Juang with a travel speed of 528 millimeters (mm) per minute for all welders. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector was injured while attempting to step from Deck Panel DP305-001 onto the gantry jig. ZPMC personnel transported the QA Inspector to the ZPMC company medical facility for immediate medical treatment. The QA Inspector did not return to Bay 1.

WELDING INSPECTION REPORT

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Summary of Conversations:

As noted in the above body of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

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| Inspected By: | Franco,Charlie | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
